

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023989**Date Inspected:** 11-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

Outside Yard – OBG Trial Assembly

This QA Inspector observed ZPMC qualified welding personnel identified as 066763 perform welding by Flux Cored Arc Welding (FCAW), on Side plate I Rib to Floor beam weld at panel point 123.5 of OBG Segment 13CE. Weld joint is identified as SEG3011F-126, 131. ZPMC Quality Control (QC) Inspector identified as Lu Li Qing was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-FCAW-3G (3F)-ESAB-Repair, which is used as per welding repair report WR-20958. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 068924 perform welding by Shielded Metal Arc Welding (SMAW), on Corner Assembly Edge plate I Rib to I Rib weld between panel points PP122.5 and 123 of OBG Segment 13CE. Weld joint is identified as CA3014A-144, 147, 104, 108. ZPMC Quality Control (QC) Inspector identified as Lu Li Qing was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-B-U2-FCM-1. See attached picture.

WELDING INSPECTION REPORT

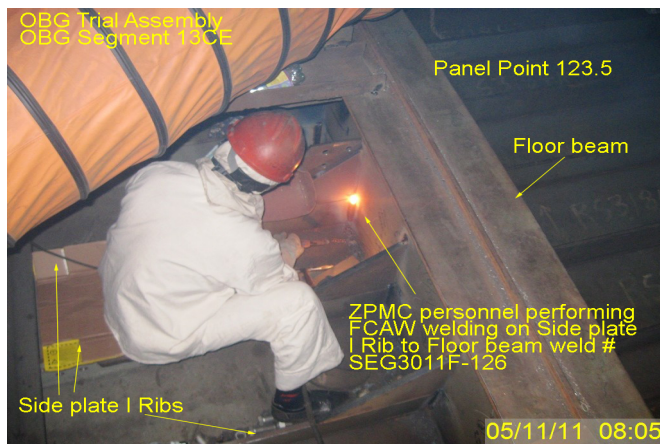
(Continued Page 2 of 3)

This QA Inspector observed ZPMC qualified welding personnel identified as 070007 perform welding by Shielded Metal Arc Welding (SMAW), on Corner Assembly Edge plate I Rib to I Rib weld between panel points PP123.5 and 124 of OBG Segment 13CE. Weld joint is identified as CA3014A-159, 124. ZPMC Quality Control (QC) Inspector identified as Lu Li Qing was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-B-U2-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 044760 perform welding by Shielded Metal Arc Welding (SMAW), on Sub Assembly part SA3013A. Weld joint is identified as SA3013A-001-007, 008, 009, 010. ZPMC Quality Control (QC) Inspector identified as Lu Li Qing was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2112-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066258 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Side plate weld at panel point PP123.5 of OBG Segment 13CE. Weld joint is identified as SEG3011G-301/302. ZPMC Quality Control (QC) Inspector identified as Lu Li Qing was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2113-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Upadhye, Anand

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer